

Foreword

These are the files for the moulding box sides. Both the printer ready STL files and the PDF files are included.

There are 3 files for the 300 mm long side. One of these is for the side in its entirety, the other two - a left and a right half - are for those whose 3D printers are not big enough to do the side in one print. These two halves join in the middle of the box side underneath the pin lug piece.

The two oddside pieces are intended to be placed under the ends of the box side during ramming up of the sand mould. In this way they avoid the need to cut down the surface of the mould at the angled ends of the side. The "ODD SIDES IN PLACE.pdf" together with "ASSEMBLY SHEET 4.pdf" files show how these pieces are to be used. Using the nail holes provided simply pin the pieces to a base board, one at either end of the pattern as per the drawing. Ram up the drag mould, turn over and remove the base board and odd side pieces then ram up the cope mould – job done.

For those of you cutting the patterns from wood rather than 3D printing please note that the 45-degree angle at the end of the sides needs to be as accurate as you can make it.

While we have done everything possible with the design of these files to make their printing, moulding, casting and subsequent machining as easy as possible you are nevertheless our "beta testers" so if you find problems or think of any improvements, please do not hesitate to reach out to us. [mmwest@hotkey.net.au] or [olfoundryman@gmail.com] Note that I may soon delete the latter address as it's a bit of a pain. 😊

While I will have released the video of our first trial casting just before sending these files to you, the video where I make all the sides using the most recent design is a little way off at the moment as the current lockdown situation is making things difficult, and being over 70 I have no intention of pushing my luck!

Kind regards and best of luck with it all, Martin West (Olfoundryman)